

Work Order ID 127716

December-17-14 1:51:30 PM

127716

Page 1

Item ID: D2581 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Bracket
 Start Date: 1/06/15 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 1/06/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2581	Rev A1

100 FLOW WATER JET 0.00 ***100*** DAS 23 15-1-8
 Waterjet 45 0 9-89

FLOW CNC Waterjet
 304, 125"
 Memo
 1-Cut as per Dwg D2581
 Dwg Rev: A1
 Prog Rev: A1
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00 ***110*** DAS 23 15-1-8
 QC 45 0 9-89
 Quality Control Memo
P 15/01/09

120 QC8- Inspect parts - second check 0.00 ***120*** DAS 38
 QC 45 9-89
 Quality Control Memo

JAN 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127716

127716

Page 2

Item ID: D2581

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Bracket

Start Date: 1/06/15 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/06/15 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Form as per dwg NC BRAKE	0.00							
130									
Brake NC	Memo	0.00		DAS 30 9-89		45			
Brake NC									

15/01/12

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

JAN 12 2015

150	Identify as per dwg & Stock Location: <u>WA004</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								

45X DH 15/1/21

DQA: _____ Date: _____



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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127716***127716***

Page 3

Item ID: D2581

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Mounting Bracket

Stop ***NS2***

Start Date: 1/06/15 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/06/15 Req'd Qty: 20.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

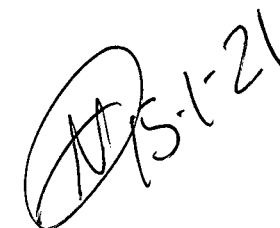
Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-01-21



DQA: _____ Date: _____



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Picklist Print

December-17-14 1:51:29 PM

Page 1

Work Order ID: 127716

127716

Parent Item: D2581

D2581

Parent Item Name: Mounting Bracket

Start Date: 1/06/15

Required Date: 1/06/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D01.07.17Added info to step 2SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	254.0000	0.0187	0.393684			
M304S11GA									**	<u>1.0</u>		DAS 23 9-89	15-1-8
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

254

122521

54

M128254

64

M129545

40

M129972

96

122521

DQA: _____ Date: _____



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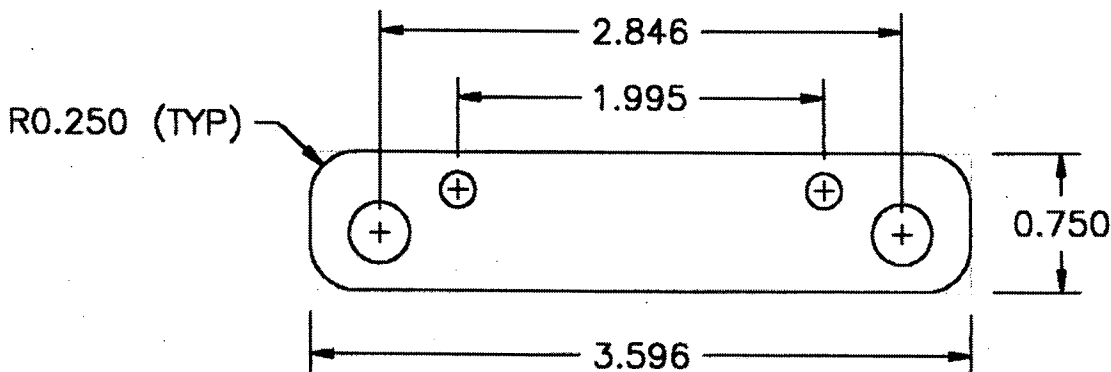
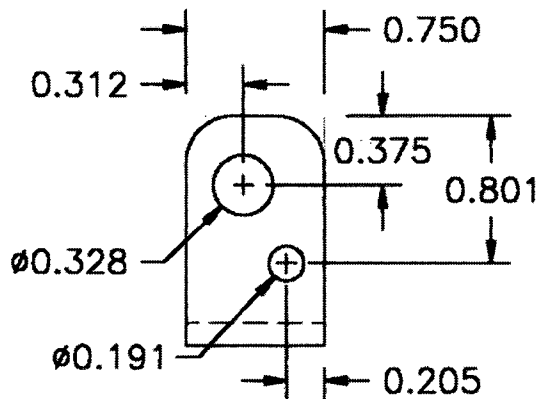
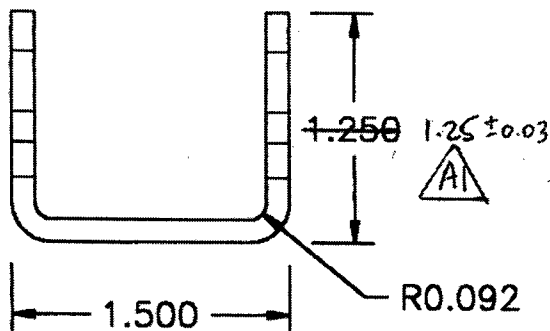
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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other



DESIGN MIKE M	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>M. M.</i>	DRAWING NO. D2581	REV. A SHEET 1 OF 1
DATE 96.06.27	TITLE MOUNTING BRACKET		SCALE 1:1
AI	CP 04.05.14		CHANGE TOLERANCE ON 1.25 DIMENSION

RELEASED
96/07/23 BW



MATERIAL: 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING
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NO. 123716 MGS
14-12-23